

## **IN THE SUBSTITUTE SPECIFICATION**

Please cancel paragraphs 010, 011, 022, 035 and 045 of the Substitute Specification of the subject application. Please replace those cancelled paragraphs with replacement paragraphs 010, 011, 022, 035 and 045, as follows.

**[010]** By the provision of air outlet openings, with diameters in the millimeter range, forces can be applied point-by-point to the material, with an impulse~~an impulse~~ of a jet, by the use of which, the material can be kept away from the respective component, or can be placed against another component. By the distribution of micro-openings in the guide element, with a high hole density and with a broad support, as a matter of priority, the effect of a formed air cushion is applied. The cross-section of bores used in prior devices were, for example, in the range of between 1 and 3 mm. The cross section of the micro-openings, in accordance with the present invention, is smaller by at least the power of ten. Substantially different effects arise from this difference in size. For example, the distance between the surface of the guide element with the openings and the web can be reduced, and because of this, flow losses, which occur outside of the effective areas of the web, can be clearly reduced.

**[011]** In contrast to prior components with openings, or with bores, having opening~~having opening~~ cross sections in the millimeter range and a hole distance of several millimeters, a substantially more homogeneous surface is provided with the formation of micro-openings on the surface. Here, micro-openings are understood to mean openings in the surface of the component which have a diameter of smaller than or equal to 500  $\mu\text{m}$ , preferably smaller than or equal to 300  $\mu\text{m}$ , and, in particular, smaller than or equal to 150  $\mu\text{m}$ . A "hole density" of the surface provided with micro-openings is at least one micro-opening per 5  $\text{mm}^2$ , which is the

equivalent of a density of .2 hole/mm<sup>2</sup> , and advantageously at least one micro-opening per 3.6 mm<sup>2</sup> which results in a density of .28 hole/mm<sup>2</sup> .

**[022]** At least one of the two web guide elements 01 of the printing group 05 configured for alternating printing and specifically at least the web guide element 01 which is arranged in the outlet area of the printing gap 10 of at least one printing unit 05 are or is embodied as a contactless operating web guide element 01, and in particular, as a rod 01, around which air flows, in a manner ~~amanner~~ as will be described in what follows, and as may be seen in Fig. 2.

**[035]** By the above-mentioned steps, a surface of an air cushion, which is as large as possible and which acts as a support, can be achieved at a width b01 of the guide element 01 or at a width b07 of the support 07, such as for ~~as for~~ example, a maximum width that may be preset for reasons of structural spacing. At a desired or at a predetermined width b01, the radius R07 of the partial circle, or of the tube used as the raw material is selected on the basis of the required web directional change, represented by way of example as the deflection  $\alpha$  of the change of direction of the web 02 in Fig. 1 in the first printing unit 05, and an appropriate partial circle is used. By this selection, a change of direction takes place as "softly" as possible and is aided by the air cushion over the largest possible area in the structural space available.

**[045]** In a preferred embodiment of the present invention, in accordance with Fig. 9, the wall 14 with the micro-bores 11 is embodied as an insert 14 or as several inserts 14 which may be arranged side by side in a support 16. Each insert 14 can be connected, either fixedly or releasably, or exchangeably in the support 16. The releasable connection is advantageous in view of possible cleaning or of an exchange of inserts 14 with different micro-perforations for adaptation to different materials, with a different mass and/or surface structure, and web widths.

In the variation of this embodiment of the present invention, with inserts 14 and/or with micro-openings substantially arranged over the full circumference, such inserts 14 can, for example, be arranged on a support 16 extending in the hollow space 04. However, an embodiment of the present invention is also advantageous wherein, as represented in Fig. 9, the insert 14 with the openings 09 is only embodied over an angle segment with a curvature, in particular with a curvature that is matched~~ismatched~~ to the path of the web.